

Order ID 126971

y, December 03, 2014 10:53:04 A

126971

JAN 2015

Page 1

J: D4434-043

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: Fwd Inboard Bracket Assembly

Start Date: 12/15/14 Start Qty: 4.00

Required Date: 12/15/14 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

4

4

Approvals:

Process Plan:

Date: 14.12.03

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D4434

C

110

110

Packaging

Packaging

Memo

0.00

0.00

4x

DAS
28
9-89

JAN 08 2015

120

120

Small Fab

Small Fab

Memo

0.00

0.00

4x

DAS
28
9-89

JAN 09 2015

1-Assemble as per dwg, do not install grommets and rubber seal.

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

(4)

DAS
38
9-89

JAN 09 2015

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 126971

126971

Page 2

Wednesday, December 03, 2014 10:53:04 A

Item ID: D4434-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Inboard Bracket Assembly
 Start Date: 12/15/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 12/15/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>m 127892</i> Memo *** MASK NUT PLATE HOLES PER DWG *** START TIME: <i>11:10</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:40</i>	0.00 0.00				<i>4</i>	<i>0</i>	<i>151-13</i>	<i>DAS 34 9-89</i>
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>4</i>	<i>0</i>	<i>00</i>	<i>15/01/14</i>
160 *160* Small Fab Small Fab	Install rubber seals and grommets. 3M 1300 batch: <i>m131012</i>	0.00 0.00				<i>X</i>	<i>DAS 28 9-89</i>	<i>JAN 14 2015</i>	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																																																																				

Work Order ID 126971

126971

Wednesday, December 03, 2014 10:53:04 A

Item ID: D4434-043

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Revision ID:

Item Name: Fwd Inboard Bracket Assembly

Start Date: 12/15/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/15/14 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***Stop ***NR2***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
170 QC Quality Control	Memo	0.00							JAN 14 2015
180	Identify as per dwg & Stock Location: _____	0.00							
180 Packaging Packaging	Memo	0.00							JAN 14 2015
190	QC21- Final Inspection - Work Order Release	0.00							
190 QC Quality Control	Memo	0.00							

① 16/6/3 JF

MF
16-6-9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Print

Wednesday, December 03, 2014 10:53:03 AM

Page 1

Work Order ID: 126971

126971

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 12/15/14

Required Date: 12/15/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA5 EC verified by:JLM IPP RevC 12.01.24
per REV.A DD verified by:EC IPP RevD 12.03.05 per REV.B
DD verified by:EC IPP REV:E 13.04.01 AS PER D4434 REV.C
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-1		Manufactured	No			110	Each	2.0000	1	4			
D4434-1									**			DAS 28 9-89	JAN 08 2015
Bracket													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST246			2					
					124489			2	2x	136466 X2			
D4434-9		Manufactured	No			110	Each	14.0000	1	4			
D4434-9									**			DAS 28 9-89	
Bracket													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					GA			14					
					120664			6					
					124039			4					
					124421			4		4			
D4435-041		Manufactured	No			110	Each	9.0000	1	4			
D4435-041									**			DAS 28 9-89	JAN 14 2015
Bracket Assembly													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST107			9					
					115926			3					
					122909			4		41			
					124188			2					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 126971

126971

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 12/15/14

Required Date: 12/15/14

Start Qty: 4.00

Required Qty: 4.00

D4441-1 Manufactured No

f 431.7478 1

D4441-1

Rubber Seal

**

DAS 28 9-89 JAN 14 2015

Location

Loc Qty

Loc Code

ST407

430.7478

120932

430.7478

ST422

1

86185

1

D4441-1 Manufactured No

f 431.7478 1

D4441-1

Rubber Seal

**

DAS 28 9-89

Location

Loc Qty

Loc Code

ST407

430.7478

120932

430.7478

ST422

1

86185

1

D4441-1 Manufactured No

f 431.7478 8

D4441-1

Rubber Seal

**

DAS 28 9-89

Location

Loc Qty

Loc Code

ST407

430.7478

120932

430.7478

ST422

1

86185

1

D4440-1 Manufactured No

160 Each 19.0000 1 4

D4440-1

Grommet

**

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

19

120257

19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 3

Wednesday, December 03, 2014 10:53:03 AM

Work Order ID: 126971

126971

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 12/15/14

Required Date: 12/15/14

Start Qty: 4.00

Required Qty: 4.00

AN525-832R6

Purchased

No

110

Each

256.0000

3

12

AN525-832R6

**

DAS
28
9-89

JAN 14 2015

Screw

LocationLoc QtyLoc Code

CA

1

m129682

1

GA

61

125303

61

12

ST329

194

m127059

9

m130325

65

m130466

120

MS20426AD3-2

Purchased

No

110

Each

18,153.00

12

48

MS20426AD3-2

**

DAS
28
9-89

JAN 08 2015

Rivet

D3-3

DAS
30
1-89

12/04/09

LocationLoc QtyLoc Code

Mezz

18153

128754

1173

8873

13276

9280

MS20426AD3-3

Purchased

No

110

Each

2,078.000

2

8

MS20426AD3-3

**

DAS
28
9-89

RIVET

LocationLoc QtyLoc Code

GA

752

M128754

752

ST313

1326

123352

312

M128754

1014

8

Wednesday, December 03, 2014 10:53:03 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____							

Picklist Print

Page 4

Wednesday, December 03, 2014 10:53:03 AM

Work Order ID: 126971

126971

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 12/15/14

Required Date: 12/15/14

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-3

Purchased

No

110

Each

4,033.000

5

20

MS20470AD4-3

**

Rivet - Universal Head

DAS
28
9-89

Location

Loc Qty

Loc Code

ST310

4033

1642

24

2193

4009

20

MS21075L08

Purchased

No

110

Each

204.0000

7

28

MS21075L 08

**

ANCHOR NUT

DAS
28
9-89

Location

Loc Qty

Loc Code

ST300

204

M126145

2

M128635

200

M128813

2

28

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					